



Rockwell

MANUFACTURING COMPANY

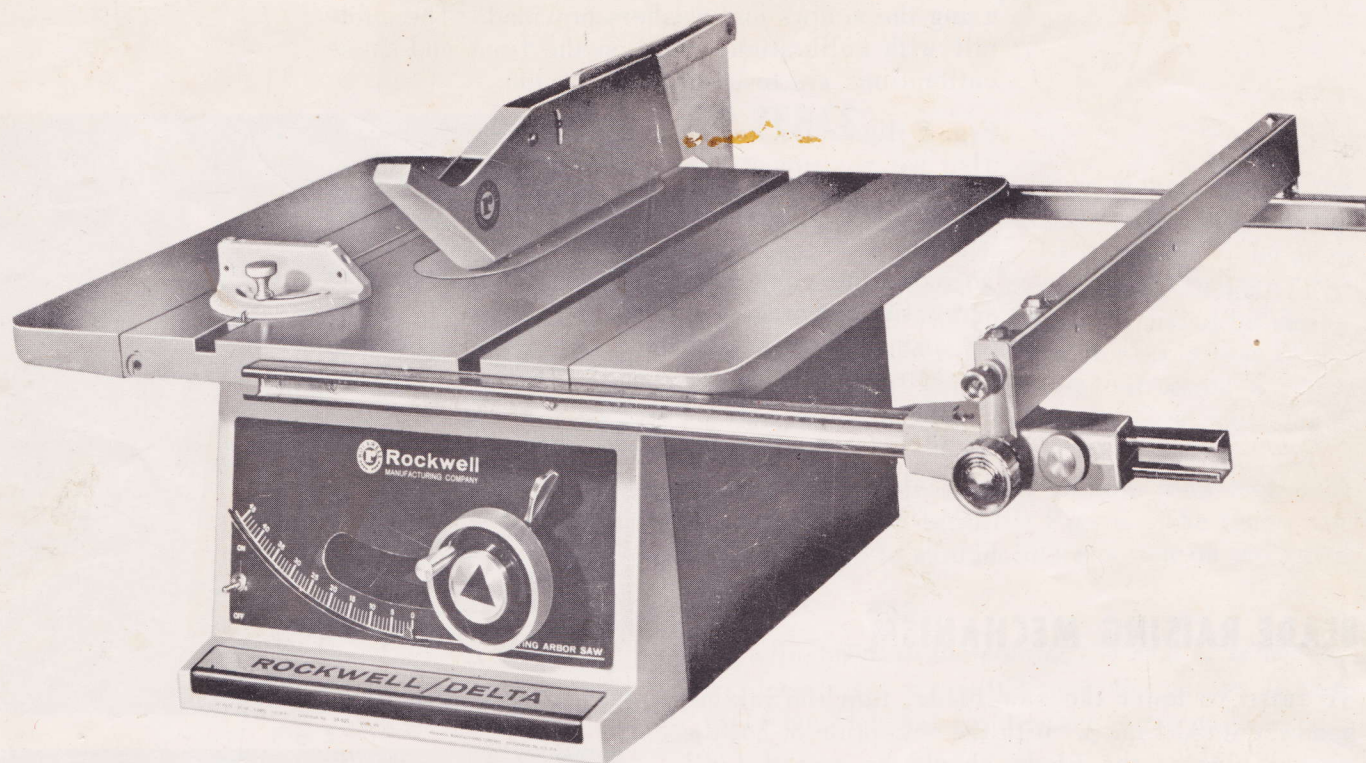
The Rockwell Building • Pittsburgh, Pa.

PM-422-15-651-0001

DATED IM-8-15-67

Model 34-625

ROCKWELL/DELTA 9" MOTORIZED CIRCULAR SAW



INTRODUCTION

The Rockwell/Delta 9" Tilting Arbor Saw you have just purchased is a quality-built machine, capable of dependable performance throughout its lifetime. In order to take full advantage of these capabilities you should thoroughly understand the construction and assembly of the saw and the proper technique for operating it. Therefore, we suggest you read this manual before operating the saw and also that you save it for future reference.

ASSEMBLING SAW TO STAND

The saw can be mounted on a suitable wood stand or bench, or the 50-108 Rockwell Steel Stand. If the saw is mounted to a wood stand or a bench, care must be taken that a hole is provided in the bench, to facilitate the removal of saw dust. If the saw is to be mounted to the 50-108 Steel Stand, assemble the stand by following the instructions supplied with the stand. Then mount the saw to the stand using the four hexagon head cap screws, washers, and nuts supplied.

MOTOR

Your Rockwell/Delta 9" Tilting Arbor Saw is equipped with a 1-3/4 HP Universal Type Motor that will operate on standard AC, 115 Volt, 60 cycle power.

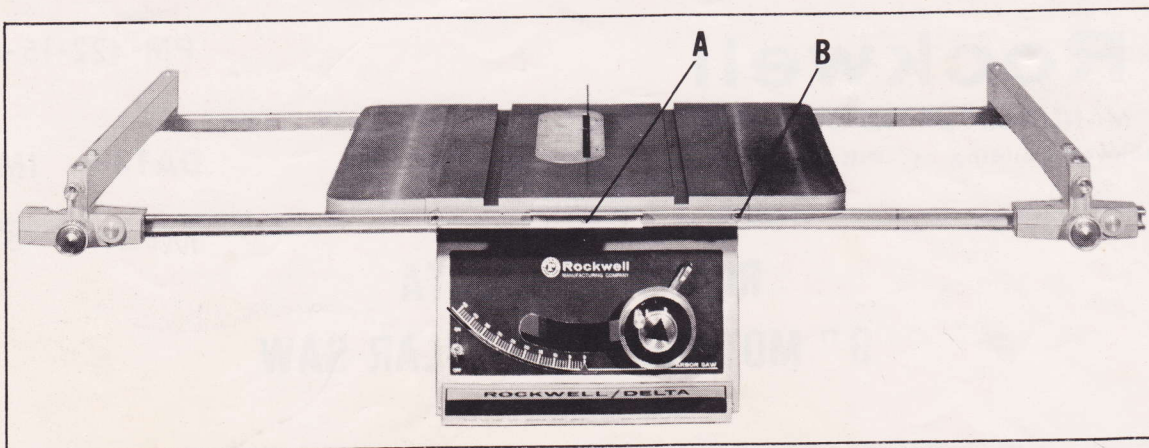


Fig. 2

ASSEMBLING GUIDE RAILS

Assemble the front and rear guide rails to the table using the screws and washers provided. The guide rail with calibrations goes on the front and these calibrations are to be on the top side.

Fig. 2 illustrates how the guide rails and fence can also be positioned to the left of the saw blade providing 24" rip capacity to the right or left of the blade.

To move the guide rails to the left simply loosen screw (A) and remove screw (B) Fig. 2. Then simply swing the guide rail over to the left and assemble screw (B) to the left hand side of the table and retighten screw (A). Follow the same procedure for the rear guide rail.

When the guide rails are used on the left hand side of the saw blade, the calibrations will be on the bottom of the rail and consequently can not be used.

BLADE RAISING MECHANISM

To raise or lower the saw blade, turn the raising handwheel (A) Fig. 3. With the exception of hollow ground blades, the blade should be raised $1/8''$ to $1/4''$ above the top surface of the material being cut. With hollow ground blades the blade should be raised to the maximum to provide greater clearance.

With the blade set at 90 degrees, the maximum depth of cut is $2 \frac{7}{8}''$.

With the blade set at 45 degrees, the maximum depth of cut is $2 \frac{1}{32}''$.

BLADE TILTING MECHANISM

To tilt the saw blade for bevel cutting, loosen the lock handle (B) Fig. 3, by moving it to the left, and turn the blade tilting handwheel (C). When the desired angle is obtained, tighten lock handle (B) Fig. 3.

The angle of the blade can be seen on the tilt angle scale conveniently located on the front of the cabinet.

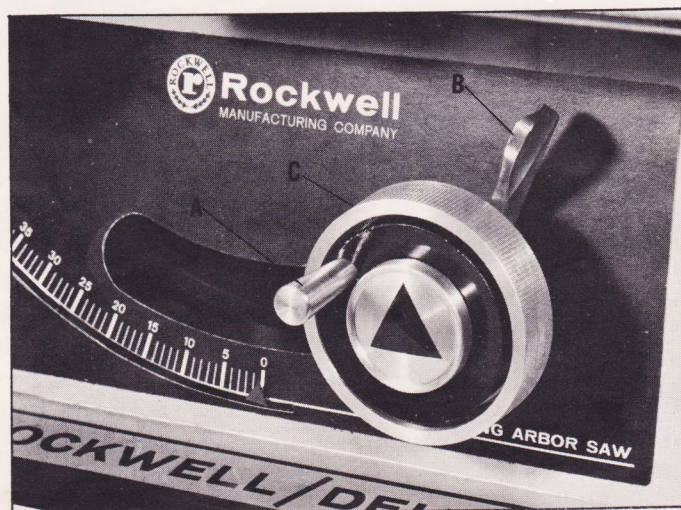


Fig. 3

TABLE INSERT

The table insert should always be flush with the table top. To adjust the table insert (A) Fig. 4, use a Phillips head screw driver and turn the adjusting screws (B) in or out until the insert is flush with the table, as shown in Fig. 4.

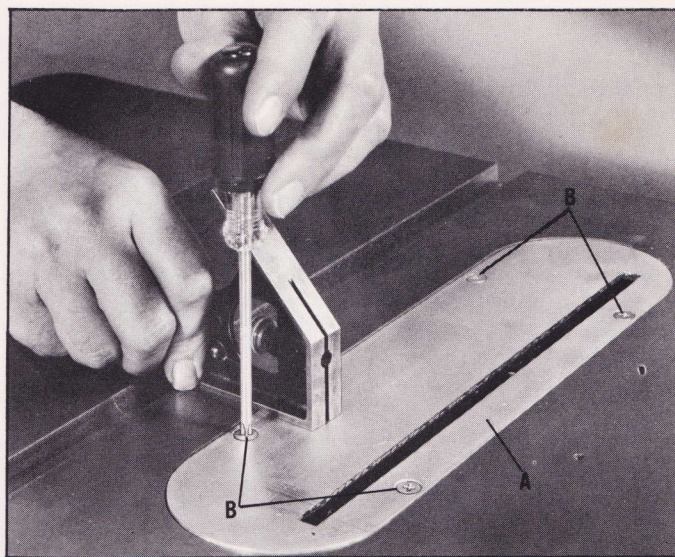


Fig. 4

RIP FENCE

The rip fence can be used on either side of the saw blade. The most common location is on the right hand side. To align the rip fence to the miter gage slot, refer to Step No. 6 under OPERATING ADJUSTMENTS. The rip fence is guided by means of guide rails fastened to the front and rear of the table. The front guide rail is calibrated to show the distance the fence is set from the saw blade.

To move the rip fence, loosen both front lock knob (A), and rear lock knob (B) Fig. 5. The fence can then be moved to the desired position on the guide rails.

If an adjustment to the pointer (D) Fig. 5, is necessary, loosen set screw (C) move the pointer to the correct position and tighten set screw (C).

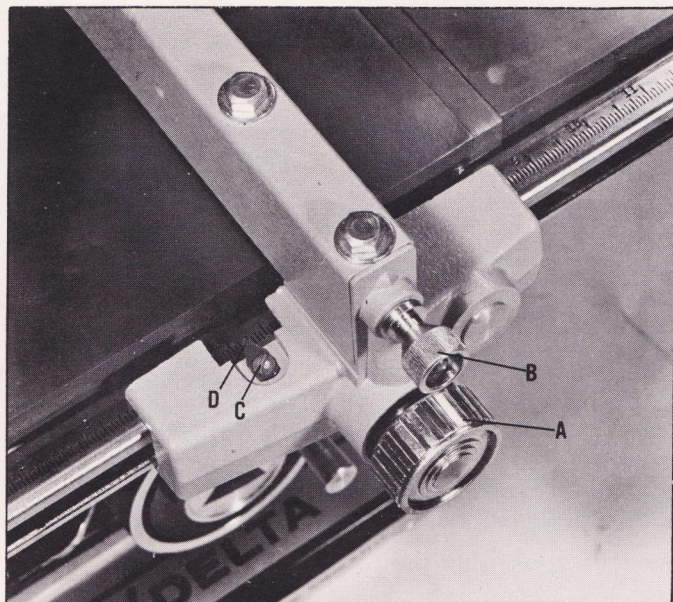


Fig. 5

SAW BLADES

The saw blade furnished with your saw is a 9" Combination Blade suitable for both crosscutting (across the grain) and ripping (with the grain.)

Saw blades should always be sharp and unless you are capable of properly sharpening or setting saw blades, we suggest you locate a reputable sharpening service to sharpen your blade.

Always keep saw blades clean.

CAUTION: Abrasive wheels of any kind should not be used with your Rockwell/Delta 9" Motorized Saw.

REMOVING SAW BLADES

To remove the saw blade from your saw, first disconnect the saw from the power source. Remove the table insert, place a block of wood against the front of the saw blade and with a wrench turn the arbor nut toward you, as shown in Fig. 6.

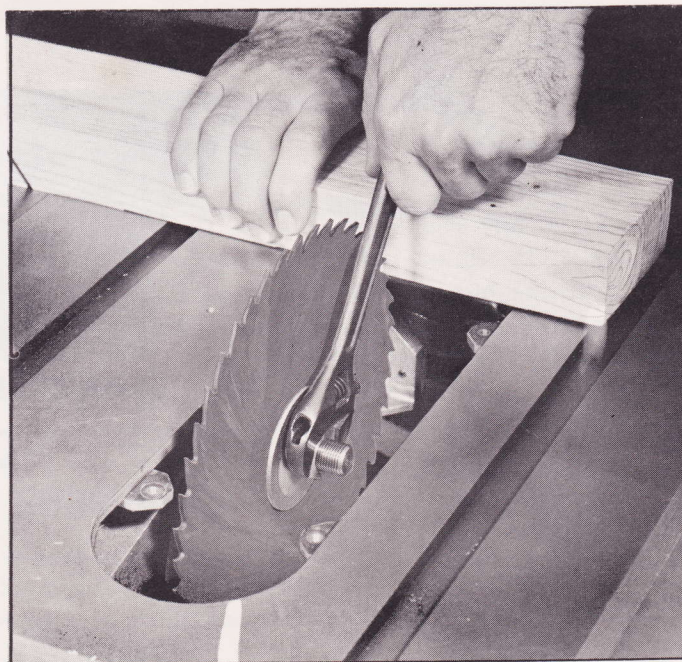


Fig. 6

OPERATING ADJUSTMENTS

The principle adjustment of your saw is the relationship between the saw blade to the fence and table.

These adjustments were made at the factory, however, during shipment they may have been disturbed.

The following adjustments should be checked and adjusted if necessary.

1. Raise the saw blade as far as it will go.
2. Set the blade at 90 degrees by loosening the locking handle and turning the tilting handwheel counterclockwise as far as it will go.

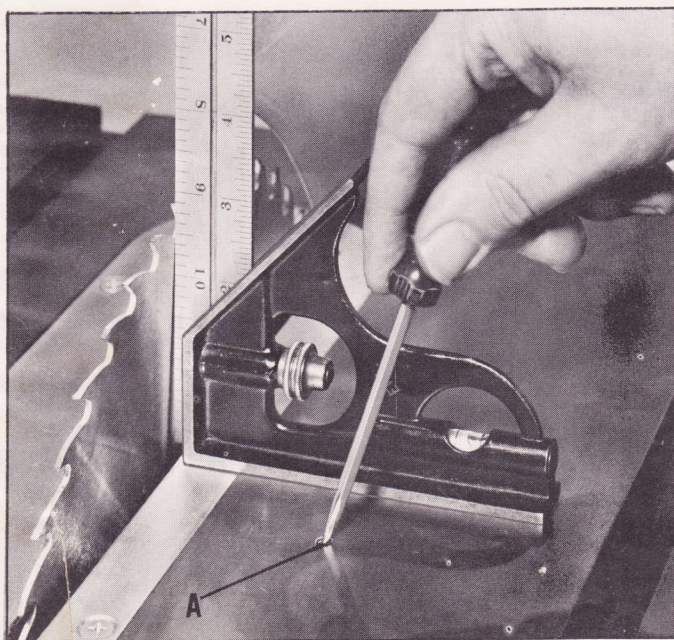


Fig. 7

3. Place a square on the table as shown in Fig. 7, and check to see if the blade is at a perfect 90 degree angle.

4. If the blade is not at 90 degrees, back off set screw (A) Fig. 7, and turn the tilting handwheel until you are certain the blade is at 90 degrees to the table. Then tighten set screw (A) Fig. 7.

5. When you are sure the blade is at 90 degrees, make sure the pointer on the tilting angle scale reads 0 degrees.

6. The blade is set parallel to the miter gage slot at the factory. The fence should be adjusted so it is parallel to the miter gage slot. To check the rip fence, set it at one of the miter gage slots. Tighten the front lock knob (A) and rear lock knob (B) Fig. 8. The fence should then line up parallel with the miter gage slot. If an adjustment is necessary loosen the fence adjusting screws (C) and rear lock knob (B) Fig. 8.

With the front lock knob (A) Fig. 8, still tight, move the back end of fence to the right or left lining it up to the miter gage slot. Then tighten the rear locking knob (B) and fence adjusting screws (C) Fig. 8.

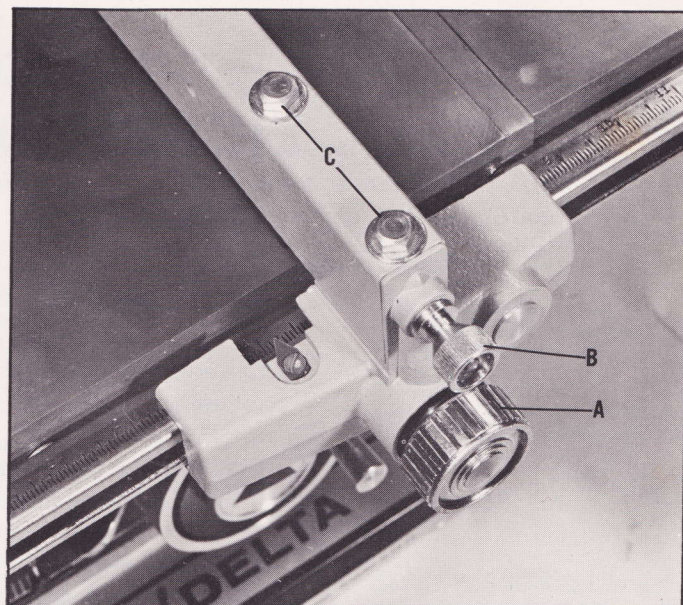


Fig. 8

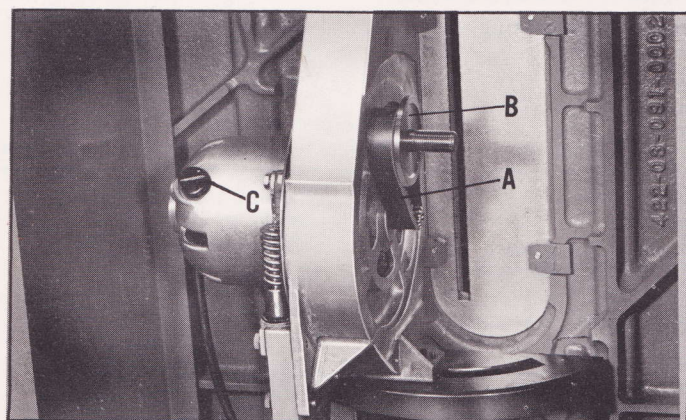


Fig. 9

BELT REPLACEMENT

Should you find it necessary to remove or replace the drive belt of your saw, proceed as follows:

1. Disconnect the saw from the power source.
2. Remove the table insert and saw blade.
3. Slide the belt (A) Fig. 9, off the motor shaft and at the same time slide off the blade arbor flange (B). NOTE: For clarity, the photograph shown in Fig. 9, is taken from the underside of the saw.
4. Reassemble in the reverse order.

BRUSHES

Brush life varies. It depends on the load on the motor. For a new machine or after a new set of brushes has been installed, check the brushes after the first 50 hours of use.

After the first check, examine them after about every 10 hours of use until such time that replacement is necessary.

When the carbon on either brush is worn to $3/16''$ in length or if either spring or shunt wire is burned or damaged in any way, replace both brushes.

The brush holders are located on the end of the motor opposite each other. One brush holder (C) can be seen in Fig. 9. If the brushes are found serviceable after removing, reinstall them in the same position as removed.

OVERLOAD PROTECTION

9'' Motorized Saws beginning with serial number DQ-7692 are equipped with overload protection. If the motor shuts off due to overloading or low voltage, let the motor cool three to five minutes, and push the reset button which is located on the left hand side of the saw cabinet. If this trouble is repeated, investigate to determine and correct the cause of the trouble. Many times this type of failure indicates the use of an extension cord which is too long or that the size of the cord is too small to carry the current required.

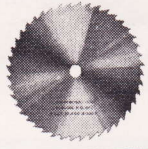
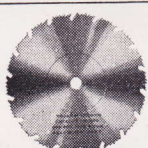
SAFETY RECOMMENDATIONS

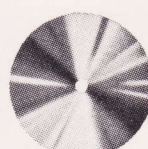
Plain sawing includes ripping and cross-cutting, plus a few other standard operations of a fundamental nature. We strongly suggest that you make use of all the conventional safety guards provided for your saw. The following safety suggestions should be followed at all times.

1. Remove tie, rings, watch, and roll up sleeves.
2. Keep saw blade sharp and free of all rust and pitch.
3. Always disconnect the saw from the power source before making adjustments.
4. Always hold the work firmly against the miter gage or fence.
5. When finished, shut the power off and do not leave the machine until the blade has come to a complete stop.
6. Taking a chance is foolhardy; always follow good safety rules when operating your saw.

ACCESSORY SAW BLADES

All with $\frac{5}{8}$ " diameter arbor hole. $1\frac{1}{2}$ lbs. each

No.	Type	Diam.
325	 Combination	8"
34-627		9"
334	 Rip	8"
33-198		9"
335	 Cross-Cut	8"
33-223		9"
326	 Hollow Ground	8"
33-227		9"

No.	Type	Diam.
33-224	 Novelty Tooth	9"
34-707	 Plywood (200 Teeth)	7"
34-840	Carbide-Tipped Comb. (24 Teeth)	9"

ROCKWELL SERVICE CENTERS

CALIFORNIA

BUENA PARK, 90620
6363 Knott Avenue
Phone: (714) 523-4000

LOS ANGELES, 90007
2400 S. Grand Avenue
Phone: (213) 749-0386

OAKLAND, 94601
445 Lesser Street
Phone: (415) 535-2424

SANTA CLARA, 95050
2305 Dela Cruz Boulevard
Phone: (408) 241-9790, 91

COLORADO

DENVER, 80207
4900 East 39th Street
Phone: (303) 388-5803

DISTRICT OF COLUMBIA

WASHINGTON, 20018
1717 Hamlin Street N.E.
Phone: (202) 529-5145

FLORIDA

NORTH MIAMI, 33160
2320 N. E. 171st Street
Phone: (305) 945-7644

GEORGIA

ATLANTA, 30301
1495 Northside Drive, N.W.
Phone: (404) 351-5434

ILLINOIS

CHICAGO, (MELROSE PARK), 60160
4533 North Avenue
Phone: (312) 921-2650

MASSACHUSETTS

BOSTON, (ALLSTON), 02134
414 Cambridge Street
Phone: (617) 782-1700

MICHIGAN

DETROIT, (SOUTHFIELD) 48075
18650 West Eight Mile Road
Phone: (313) 358-1000

MINNESOTA

MINNEAPOLIS, (ST. LOUIS PARK), 55400
4310 West 36½ Street
Phone: (612) 920-3087

MISSOURI

KANSAS CITY, 64105
1649 Jarboe Street
Phone: (816) 221-2070

ST. LOUIS, 63139
2348 Hampton Avenue
Phone: (314) 644-3166

NEW JERSEY

UNION, 07083
945 Ball Avenue
Phone: (201) 964-1730

NEW YORK

LONG ISLAND CITY, 11106
23-56 Broadway
Phone: (212) 721-3536

MANHATTAN, 10013
132 Lafayette Street
Phone: (212) 966-2726

SYRACUSE, 13201
700 Marcellus Street
Phone: (315) 476-4231

NORTH CAROLINA

CHARLOTTE, 28209
3601 South Boulevard
Phone: (704) 525-4410

OHIO

CINCINNATI, 45203
906 Dalton Street
Phone: (513) 241-2737

CLEVELAND, 44114
1234 East 26th Street
Phone: (216) 621-6329

COLUMBUS, 43214
4560 Indianola
Phone: (614) 263-0929

OREGON

PORTLAND, 97232
2755 Northeast Broadway
Phone: (503) 288-6888, 89

PENNSYLVANIA

PHILADELPHIA, 19124
4210 MacAlester Avenue
Phone: (215) 455-7907

PITTSBURGH, 15208
400 North Lexington Avenue
Phone: (412) 241-8400 (Ext. 252)

RHODE ISLAND

EAST PROVIDENCE, 02914
973 Waterman Avenue
Phone: (401) 434-3620

TEXAS

DALLAS, 75247
2934 Iron Ridge Street
Phone: (214) 631-1890

WASHINGTON

SEATTLE, 98101
1918 Minor Avenue
Phone: (206) 622-4576

WISCONSIN

MILWAUKEE, 53222
10700 West Burleigh Street
Phone: (414) 774-3650

CANADA

CALGARY, ALBERTA
4411 Manatoba Street, S.E.
Phone: (403) 244-2136

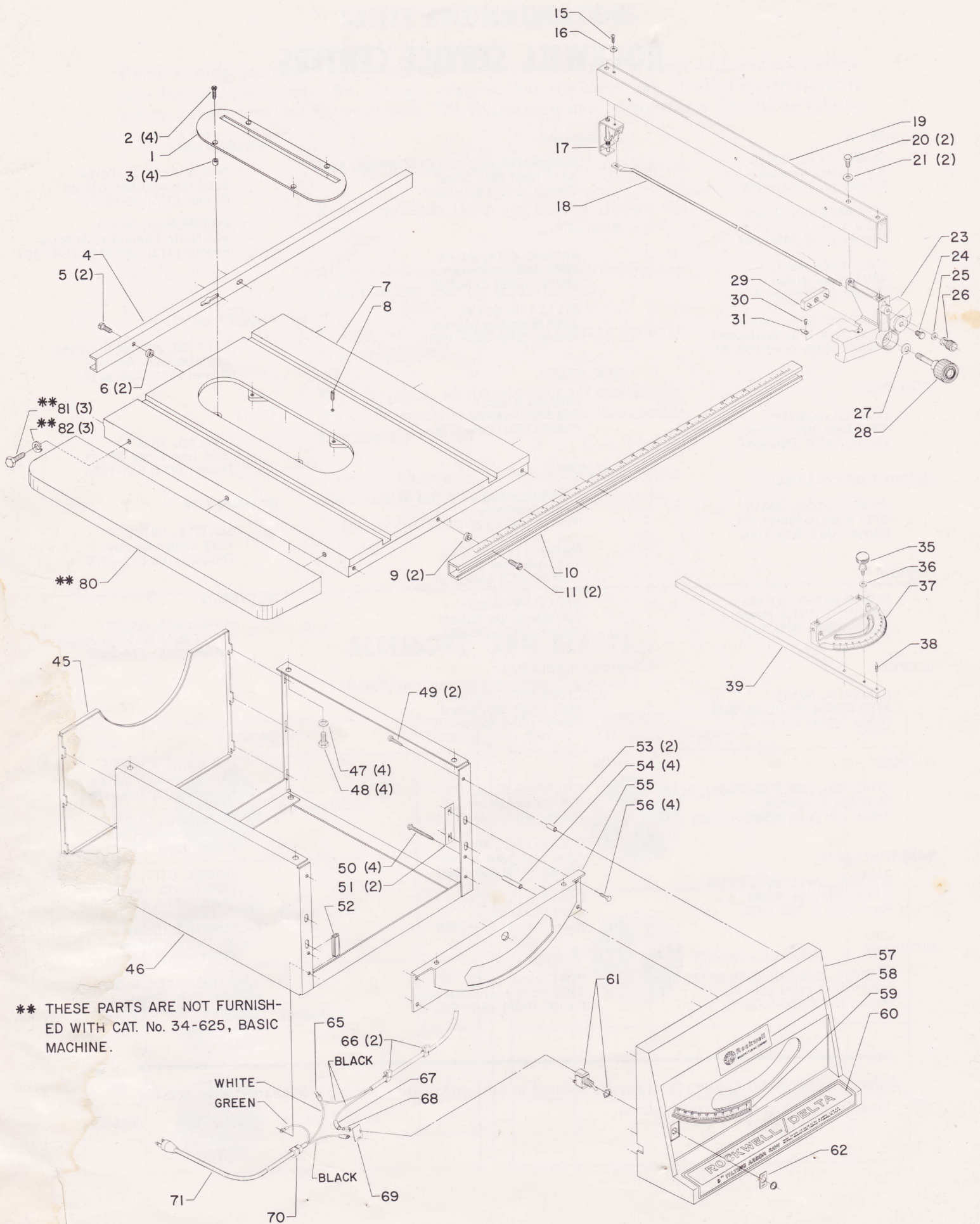
MONTREAL, QUEBEC
7609 St. Hubert Street
Phone: (514) 274-5693

QUEBEC CITY, QUEBEC 3
1199 Fourth Avenue
Phone: (418) 529-0236

TORONTO (Downsview), ONTARIO
51 Wardlaw Avenue
Phone: (416) 244-5577

VANCOUVER, B.C.
1970 Pine Street
Phone: (604) 736-7355

Authorized Rockwell Service Stations are located in all large cities. For the one nearest you, see the classified section in your phone book.



Replacement Parts

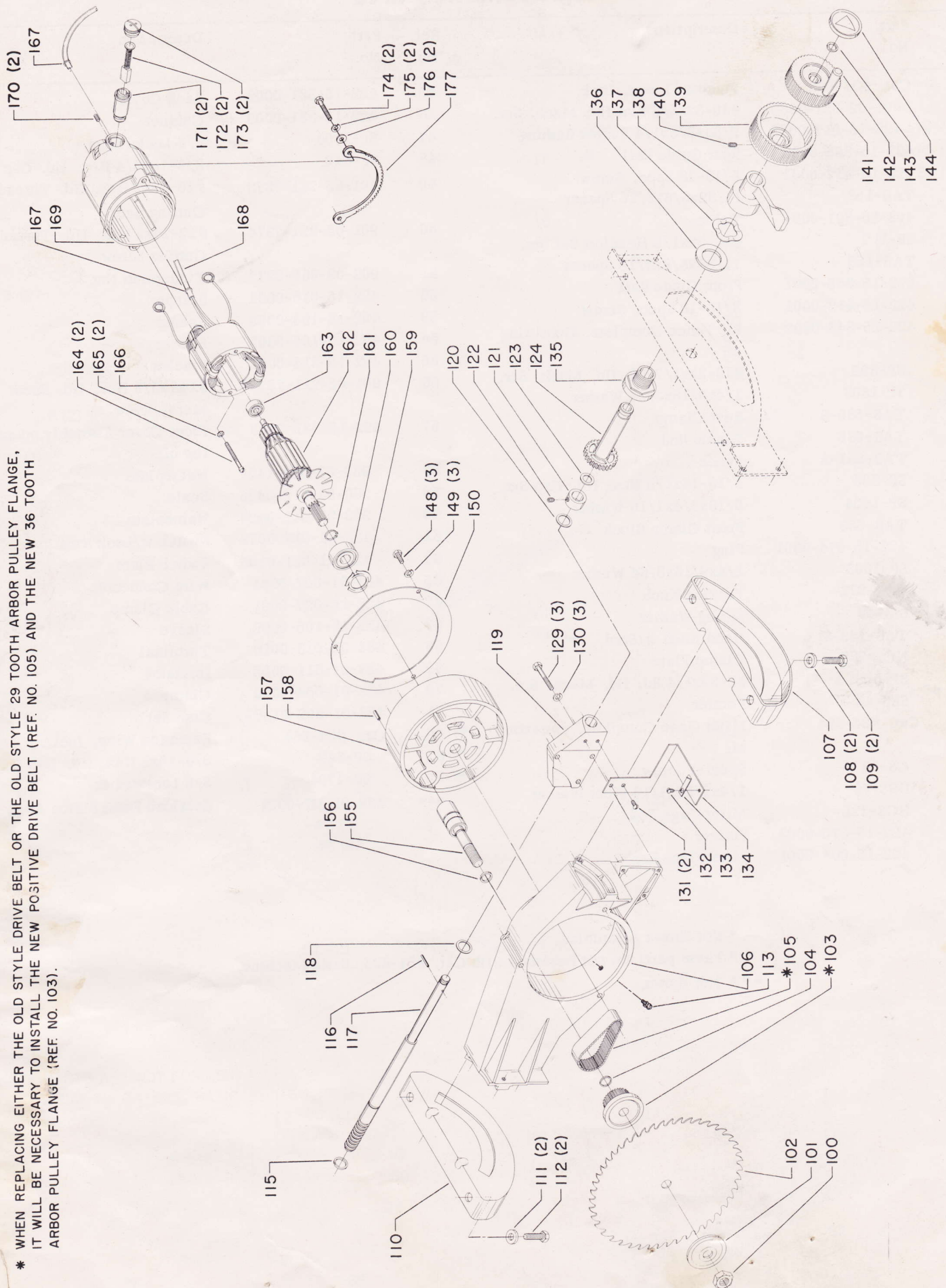
Ref. No.	Part. No.	Description	Ref. No.	Part No.	Description
1	Cat. #34-822	Standard Insert, Incl:	45	422-15-331-0002	Back Cover
2	901-02-321-7630	#10-32x5/8 Flat Hd. Mach. Scr.	46	422-15-331-0003	Cabinet
3	422-16-017-0003	9/64x3/8x1/4 Rubber Bushing	47	SP-1704	3/8 Lockwasher
4	422-15-355-0002	Rear Guide Rail	48	SP-640	3/8-16x3/4 Hex. Hd. Cap Scr.
5	422-15-412-0001	5/16-18 Spec. Screw	49	901-05-221-7373	#12-24x1 Hex. Hd. Thread
6	TAB-153	11/32x5/8x3/16 Spacer			Cutting Screw
7	422-15-391-0001	Table	50	901-05-221-7374	#12-24x2 Hex. Hd. Thread
8	SP-112	#10-32x1/2 Headless Set Scr.			Cutting Screw
9	TAB-153	11/32x5/8x3/16 Spacer	51	902-03-060-2977	Tinnerman Nut
10	422-15-355-0001	Front Guide Rail	52	422-15-016-0001	Bumper
11	422-15-412-0001	5/16-18 Spec. Screw	53	422-16-104-0003	Spacer
*	422-15-343-0002	Rip Fence Complete, Consisting of:	54	422-16-104-0002	Spacer
15	SP-525	#10-24x1/2 Rd. Hd. Mach. Scr.	55	422-15-314-0002	Bracket
16	SP-1603	1/4x9/16x3/64 Washer	56	901-05-211-7372	#14Ax5/8 Hex. Hd. Sheet
17	TAB-580-S	Rear Clamp			Metal Screw
18	TAB-585	Clamp Rod	57	422-15-331-0005	Front Cover Assembly, consist-
19	TAB-551-A	Fence			ing of:
20	SP-605	5/16-18x1/2 Hex. Hd. Cap Scr.	58	960-02-012-1431	Nameplate
21	SP-1604	5/16x3/4x1/16 Washer	59	960-03-012-0425	Scale
23	TAB-550	Front Clamp Block	60	960-03-012-0423	Nameplate
24	422-15-074-0001	Plug	61	438-01-017-0079	Switch w/Lock Nuts
25	SP-1603	1/4x9/16x3/64 Washer	62	438-01-021-0105	Switch Plate
26	NCS-272	Knurled Knob	65	438-01-007-0041	Wire Connector
27	BM-45	Spring Washer	66	422-15-027-0001	Cable Clamp
28	TAB-148-S	Hand Knob w/Stud	67	422-16-105-0002	Sleeve
29	NCS-252	Clamp Plate	68	438-01-018-0026	Terminal
30	SP-558	#8-32x1/4 Rd. Hd. Mach. Scr.	69	438-01-011-0035	Insulator
31	SBS-46	Pointer	70	438-01-004-0050	Clamp
*	Cat. #34-834	Miter Gage Complete, consisting of:	71	438-01-302-0186	Cord Set
35	CS-18	Special Screw	** 80	Cat. #34-864	Extension Wing, Incl.:
36	DSS-79	1/4x9/16x1/16 Fiber Washer	** 81	SP-642	3/8-16x1 Hex. Hd. Cap Scr.
37	HOS-125	Miter Gage Body	** 82	SP-1704	3/8 Lockwasher
38	422-15-375-0003	Pointer	***	438-01-317-0027	Overload Reset Button Assy.
39	422-15-004-0001	Miter Gage Bar			

* Not Shown Assembled

* * These parts are not furnished with Cat. #34-625, Basic Machine.

*** Not shown.

* WHEN REPLACING EITHER THE OLD STYLE DRIVE BELT OR THE OLD STYLE 29 TOOTH ARBOR PULLEY FLANGE, IT WILL BE NECESSARY TO INSTALL THE NEW POSITIVE DRIVE BELT (REF. NO. 105) AND THE NEW 36 TOOTH ARBOR PULLEY FLANGE (REF. NO. 103).



Replacement Parts

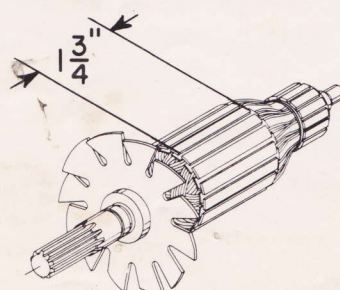
Ref. No.	Part No.	Description	Ref. No.	Part No.	Description
100	902-01-201-8563	5/8-18 Arbor Nut	139	422-16-400-0001	Tilt Handwheel, incl:
101	LTA-411	Flange	140	SP-232	1/4-20 x 3/8 Hex. Soc. Set Scr.
102	Cat. #34-627	9" Combination Blade	141	422-16-400-0002	Elevating Handwheel, incl:
** 103	422-16-403-0001	Arbor Pulley Flange (39 Teeth)	142	422-16-071-0001	Pin
104	904-07-131-6238	5/8 x 3/4 x 1/16 Washer	143	908-13-062-0865	"O" Ring
** 105	925-01-032-1061	Positive Drive Belt	144	422-16-020-0001	Cap
106	422-16-014-0001	Bracket	148	SP-611	1/4-20 x 1/2 Hex. Hd. Cap Scr.
107	422-16-395-0001	Trunnion	149	SP-1702	1/4 Lockwasher
108	904-01-032-0661	13/32 x 7/8 x .180 Washer	150	422-15-079-0001	Retainer
109	SP-642	3/8-16 x 1 Hex. Hd. Cap Scr.	*	438-02-314-0416	Motor Assembly Complete, consisting of:
110	422-16-395-0001	Trunnion	155	422-16-406-0001	Arbor Bearing Assembly, incl:
111	904-01-032-0661	13/32 x 7/8 x .180 washer	156	904-15-012-0294	Retaining Ring
112	SP-642	3/8-16 x 1 Hex. Hd. Cap Scr.	157	422-16-035-0001	Motor End Bell
113	907-01-050-5241	Grease Fitting	158	SP-2707	5/32 x 1/2 Roll Pin
* 114	422-15-314-0001	Control Shaft Bracket Assembly, consisting of:	159	SP-7355	Bearing Load Spring
115	904-15-012-0295	Retaining Ring	160	SP-5335	Ball Bearing
116	SP-2704	1/8 x 3/4 Roll Pin	161	904-15-012-0293	Retaining Ring
117	422-15-106-0001	Control Shaft	*** 162	438-02-335-0002	Armature Assembly
118	241-52	3/4 x 1 1/16 x 1/32 Fiber Washer	163	920-04-021-6624	Ball Bearing
119	422-15-014-0001	Control Shaft Bracket	*** 164	901-02-052-0717	#10-32 x 2 1/4 Fil. Hd. Mach Screw
120	241-52	3/4 x 1 1/16 x 1/32 Fiber Washer	165	SP-1795	#10 Ext. Tooth Lockwasher
121	904-10-991-5996	Set Collar, incl:	*** 166	438-02-336-0002	Field Assembly
122	SP-208	1/4-20 x 1/4 Hex. Soc. Set Scr.	167		Staple Ring
123	904-07-011-7783	37/64 x 7/8 x 1/32 Fiber Washer	168	438-01-011-0029	Insulating Tubing
124	422-16-351-0001	Gear (24 teeth) w/Sleeve	169	422-16-031-0001	Motor Cover
129	901-01-060-3124	1/4-20 x 1 1/2 Hex. Hd. Cap Scr.	170	SP-154	#10-32 x 3/8 Headless Set Scr.
130	SP-1702	1/4 Lockwasher	171	438-02-011-0001	Brush Holder
131	SP-561	#10-32 x 3/8 Rd. Hd. Mach Scr.	172	438-02-007-0001	Brush
132	SP-558	#8-32 x 1/4 Rd. Hd. Mach. Scr.	173	438-02-011-0002	Brush Cap
133	422-15-375-0001	Pointer	174	SP-614	1/4-20 x 1 1/4 Hex. Hd. Cap Screw
134	422-15-360-0001	Holder	175	SP-1702	1/4 Lockwasher
135	422-16-027-0002	Tilt Clamp	176	SP-1614	9/32 x 5/8 x 1/16 Washer
136	904-01-031-7718	1 3/16 x 2 x 1/8 Washer	177	422-16-051-0001	Elevating Gear
137	928-06-011-8894	Wavy Spring Washer			
138	422-16-067-0001	Lock Lever			

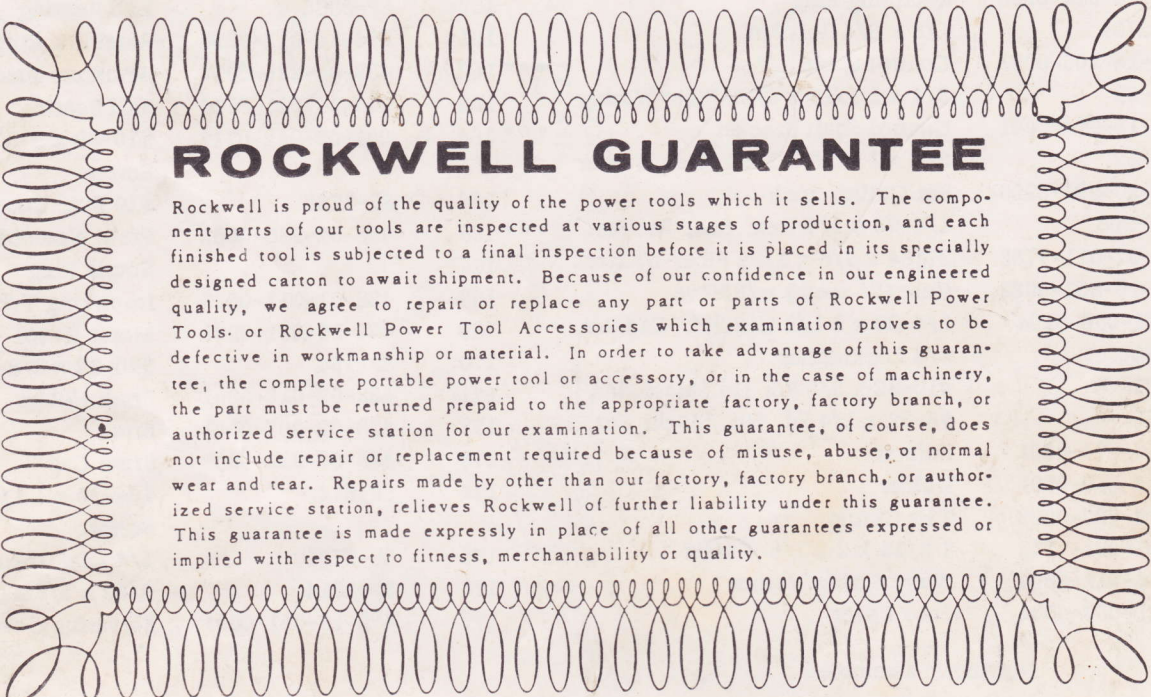
* Not shown assembled

** When replacing either the old style drive belt or the old style 29 tooth arbor pulley flange, it will be necessary to install the new positive drive belt (Ref. No. 105) and the new 36 tooth arbor pulley flange (Ref. No. 103).

*** The armature & field assemblies used on early model 9" Motorized Saws had an armature stack length of 1 1/4". These parts are no longer available. When replacing these parts it will be necessary to install new armature & field assemblies (Ref. No. 162 and 166) with an armature stack length of 1 3/4", and longer field screws (Ref. No. 164). See drawing at bottom of page for armature stack dimension.

STACK LENGTH
NEW STYLE
ARMATURE ASSEMBLY





ROCKWELL GUARANTEE

Rockwell is proud of the quality of the power tools which it sells. The component parts of our tools are inspected at various stages of production, and each finished tool is subjected to a final inspection before it is placed in its specially designed carton to await shipment. Because of our confidence in our engineered quality, we agree to repair or replace any part or parts of Rockwell Power Tools or Rockwell Power Tool Accessories which examination proves to be defective in workmanship or material. In order to take advantage of this guarantee, the complete portable power tool or accessory, or in the case of machinery, the part must be returned prepaid to the appropriate factory, factory branch, or authorized service station for our examination. This guarantee, of course, does not include repair or replacement required because of misuse, abuse, or normal wear and tear. Repairs made by other than our factory, factory branch, or authorized service station, relieves Rockwell of further liability under this guarantee. This guarantee is made expressly in place of all other guarantees expressed or implied with respect to fitness, merchantability or quality.